

Work Order ID 157807

Tuesday, March 28, 2017 1:30:11 PM

157807

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Item ID: 647.7501 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Cutter Assembly
Start Date: 4/3/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/7/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SHCEDULED/C

Approvals: Process Plan: mf Date: 17-3-28 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.7500	A								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.93							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R RTV LOCTITE 598: <u>136701</u>								
	exp. date: <u>10/18</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.02							
Quality Control									

DAS
6
9-89

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DAS
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Item ID: 647.7501 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lower Cutter Assembly
Start Date: 4/3/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 4/7/2017 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging	Identify as per dwg & Stock Location. <u>CC6001</u>	0.00							
Packaging	Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.01							
150 *150* QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.10							

17/4/6 JH

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647 7501

Start Date: 4/3/2017**Required Date: 4/7/2017**

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813 *647 7813* Center Plate, Lower		Manufactured	No			110	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	**			DAS 6 9-89	APR 03 2017
				CCK114		4							
				153834		4							
647.7810 *647 7810* Bracket A		Manufactured	No			110	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	**			DAS 6 9-89	APR 03 2017
				CCK077A		5							
				155100		5							
647.7811 *647 7811* Bracket B		Manufactured	No			110	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	**			DAS 6 9-89	APR 03 2017
				CCK077A		5							
				155101		5							
646.3015 *646 3015* Blade		Manufactured	No			110	Each	14.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	**				
				cck103		14							
				153795		4							
				156837		10							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

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Work Order ID: 157807

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Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

647.7601

Manufactured No

110 Each

0.0000

1

1

647 7601

Lower Deflector Assembly

**

157775

DAS
6
9-89

647.7815

Manufactured No

110 Each

4.0000

1

1

647 7815

Fwd Bracket

**

DAS
6
9-89

APR 03 2017

647.7814

Manufactured No

110 Each

4.0000

1

1

647 7814

Fwd Bracket

**

DAS
6
9-89

APR 03 2017

647.7816

Manufactured No

110 Each

6.0000

1

1

647 7816

Aft Bracket

**

DAS
6
9-89

APR 03 2017

647.7817

Manufactured No

110 Each

3.0000

1

1

647 7817

Aft Bracket

**

DAS
6
9-89

APR 03 2017

Location

Loc Qty

Loc Code

CCK114

4

153331

4

Location

Loc Qty

Loc Code

CCK114

4

153332

4

Location

Loc Qty

Loc Code

CCK114

6

153618

6

Location

Loc Qty

Loc Code

CCK115

3

153334

3

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER :					

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Work Order ID: 157807

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Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 4/3/2017

Required Date: 4/7/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

110

Each

1,634.000

26

26

DAS
6
9-89

NAS1149FN832P

Washer

**

APR 03 2017

Location

Loc Qty

Loc Code

GA

347

M135058

232

M136182

115

ST263

1287

M136866

1287

26

MS21042-3

MS21042L3

Purchased

No

110

Each

0.0000

3

3

MS21042-3

Nut

**

137073

DAS
6
9-89

APR 03 2017

MS21042-08

MS21042L08

Purchased

No

110

Each

0.0000

13

13

MS21042-08

USE MS21042L08

**

136975

DAS
6
9-89

APR 03 2017

NAS1149F0332P

Purchased

No

110

Each

2,660.000

6

6

NAS1149F0332P

Washer

**

DAS
6
9-89

APR 03 2017

Location

Loc Qty

Loc Code

GA

335

m133709

335

ST262

2325

m136835

525

m137075

1800

6

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 157807

157807

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 4/3/2017

Requir

Start Qty: 1.00

Requi

MS27039-08-19

Purchased

No

110

Each

285.0000

7

7

MS27039-08-19

**

DAS

APR 03 2017

Screw

Location

Loc Qty

Loc Code

GA

62

m135948

62

over006

100

m137061

100

ST277

123

m136851

73

m136975

50

MS27039-1-19

Purchased

No

110

Each

284.0000

3

3

MS27039-1-19

**

DAS

APR 03 2017

Screw

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

204

m136648

4

m137075

200

MS27039-08-24

Purchased

No

110

Each

210.0000

6

6

MS27039-08-24

**

DAS

APR 03 2017

Screw (MS27039-0824)

Location

Loc Qty

Loc Code

GA

115

124326

115

ST277

95

124326

95

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WORK ORDER NON-CONFORMANCE / UPDATE

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Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					